

Please amend the claims as follows:

1. (Currently Amended) A method of electrocoating electrically conductive three-dimensional substrates (2) in a continuous installation (1) comprising supplying an electrocoating tank (1.1) ~~containing the~~ with electrocoat material, wherein said electrocoating tank comprises an overflow tank (1.2) ~~containing the~~ for receiving electrocoat material, at least one circulating pump (1.3) for drawing off the electrocoat material on the base (1.4) of the overflow tank (1.2), at least one circulating pump (1.5) for drawing off the electrocoat material on the tank base (1.6) at the end (1.7) of the electrocoating tank (1.1) that is opposite the overflow tank (1.2), at least two flood pipes (1.8) for returning the electrocoat material drawn off by way of the circulating pumps (1.3) and (1.5) to the electrocoating tank (1.1) at its base (1.6) in such a way that in the electrocoating tank (1.1) in the longitudinal direction a directed tank flow (1.9) is produced and maintained, the tank flow (1.9) in the area of the tank base (1.6) being opposite to the tank flow (1.9) in the area of the bath surface (1.10), and at least one conveying device (1.11) with means of transporting the substrates (2) to the electrocoating tank (1.1), rotating and immersing the substrates (2) in the electrocoating tank (1.1) at one end thereof in the immersing area (1.12), transporting the substrates (2) through the electrocoating tank (1.1) in the longitudinal direction, and rotating and emerging the substrates from the electrocoating tank (1.1) at its other end, as viewed in the transport direction, in the emerging area (1.13), wherein the substrates (2)

- I. are connected as cathode or anode and
- II. with the aid of the conveying device or devices (1.11)
 - II.1 are supplied over the overflow tank (1.2) to the immersing area (1.12) of the electrocoating tank (1.1),
 - II.2 on immersion in the electrocoating tank (1.1) are rotated about a horizontal axis perpendicular to the transport direction at an angle of $> 100^\circ$ to the original position,
 - II.3 are passed in the new orientation through the electrocoating tank (1.1) and coated,
 - II.4 on emersion from the electrocoating tank (1.1) are rotated in the emerging area (1.13) about a horizontal axis perpendicular to the transport direction back into the original position, and
 - II.5 following emersion are passed on for further processing,

which comprises

drawing off the electrocoat material ~~drawn off~~ by way of the circulating pumps (1.3) and (1.5) being returned by way of the flood pipes (1.8) to the base (1.6) of the electrocoating tank (1.1) in such a way as to produce and maintain a directed tank flow (1.9) which flows in the transport direction of the substrates (2) in the area of the tank base (1.6) and opposite to the transport direction of the substrates (2) in the area of the bath surface (1.10).

- 2. (Original) The method as claimed in claim 1, **wherein** the substrates (2) have cavities.

3. (Currently Amended) The method as claimed in claim 1 ~~or 2~~, **wherein** the substrates (2) are rotated in the transport direction.

4. (Currently Amended) The method as claimed in ~~any of claims 1 to 3~~ claim 1, **wherein** the substrates (2) are vehicle bodies, radiators or casings of washing machines, dishwashers or ovens.

5. (Currently Amended) The method as claimed in ~~any of claims 1 to 4~~ claim 1, **wherein** the substrates (2) are oriented transverse to the axis of rotation or longitudinally to the axis of rotation.

6. (Currently Amended) The method as claimed in ~~any of claims 1 to 5~~ claim 1, **wherein** on immersion in the electrocoating tank (1.1) the substrates (2) are rotated in the transport direction at an angle of about 180° or 180° to the original position.

7. (Currently Amended) The method as claimed in ~~any of claims 1 to 6~~ claim 1, **wherein** on transport through the electrocoating tank the substrates (2) are moved.

8. (Currently Amended) The method as claimed in ~~any of claims 1 to 7~~ claim 1, **wherein** the substrates (2) are connected as cathode.

9. (Original) The method as claimed in claim 8, **wherein** the electrocoat material is a cathodically depositable electrocoat material.

10. (Currently Amended) The method as claimed in ~~any of claims 1 to 9~~ claim 1, **wherein** the electrocoat material is drawn off by means of the circulating pumps (1.3) and (1.5) is filtered (1.14) before being returned to the electrocoating tank (1.1).

11. (Original) The method as claimed in claim 10, **wherein** the electrocoat material drawn off is subjected to ultrafiltration.

12. (Currently Amended) The method as claimed in ~~any of claims 1 to 11~~ claim 1, **wherein** the continuous installation (1) comprises at least one power supply, electronic, mechanical, and pneumatic measurement and control devices, electric motors, overflow devices, heat exchangers, devices for the supply of electrocoat material, electrocoat material components, and neutralizing agents, ultrafiltration units, filters, anolyte circuits for the cathodically depositable electrocoat material, and rinsing zones.

13. (Original) A continuous installation (1) for implementing the method as claimed in any of claims 1 to 12, comprising

- an electrocoating tank (1.1) containing the electrocoat material,
- an overflow tank (1.2) containing the electrocoat material,
- at least one circulating pump (1.3) for drawing off the electrocoat material on the base (1.4) of the overflow tank (1.2),
- at least one circulating pump (1.5) for drawing off the electrocoat material on the tank base (1.6) at the end (1.7) of the electrocoating tank (1.1) that is opposite the overflow tank (1.2),
- at least two flood pipes (1.8) for returning the electrocoat material drawn off by way of the circulating pumps (1.3) and (1.5) to the electrocoating tank (1.1) at its base (1.6) in

such a way that in the electrocoating tank (1.1) in the longitudinal direction a directed tank flow (1.9) is produced,

- the tank flow (1.9) in the area of the tank base (1.6) being opposite to the tank flow (1.9) in the area of the bath surface (1.10),
- at least one conveying device (1.11) with means of transporting the substrates (2) to the electrocoating tank (1.1), rotating and immersing the substrates (2) in the electrocoating tank (1.1) at one end thereof in the immersing area (1.12), transporting the substrates (2) through the electrocoating tank (1.1) in the longitudinal direction, and rotating and emerging the substrates from the electrocoating tank (1.1) at its other end in the emerging area (1.13),
- an immersing area (1.12) at the end of the electrocoating tank (1.1), to which the overflow tank (1.2) connects, and
- an emerging area (1.13) at the other end of the electrocoating tank (1.1) as viewed in the transport direction of the substrates,

wherein the directed tank flow (1.9) in the area of the bath surface (1.10) is opposite to the transport direction of the substrates (2).

14. (Original) The continuous installation (1) as claimed in claim 13, **which comprises** at least one power supply, electronic, mechanical, and pneumatic measurement and control devices, electric motors, pumps, overflow devices, heat exchangers, devices for the supply of electrocoat material, electrocoat material components, and neutralizing agents, ultrafiltration units, filters, anolyte circuits for the cathodically depositable electrocoat material, and rinsing zones.